QC8- Inspect parts - second check

Memo

160

160

Quality Control

Work Order ID 121924 *121924* Page 1 Monday, July 07, 2014 9:49:42 AM Item ID: D3453-3 Accept *N900040100* Setup Start **Revision ID: Item Name:** Clevis **Start Date:** 7/07/14 **Start Qty: 10.00** *10* **Cust Item ID:** Required Date: 7/07/14 Req'd Qty: 10.00 *10* Customer: Reference: Run Start **Approvals:** Process Plan: MIJ Date: 14-07-07 Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number **Qty** Stamp **Draw Nbr Revision Nbr** D3453 Rev B 100 0.00 *100* Doosan 0.00 Memo Doosan Lathe 1-Turn as per Folio FA578 Rev: AA & O Dwg D3453 Rev: B 2- Deburr as per dwg D3453 150 QC2- Inspect parts off machine FAI/FAIB 0.00 DAS *150* OC Memo 0.00 14/10/06 Quality Control

0.00

0.00

DQA:			Date:						/ -					DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPD		ork Order up	odate only		AEROSPACE
						DISPOSITION					EPARTMENT,		<u> </u>	
Work Orde	er: ˌ						,				7			e to seine
Part N	۱o.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	۱o.	****				Suspected Unapproved		men	~ - - -	Composite		Supplier	-	
Root					Desc	ription of work order update		Initial	Action	n	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
					•		FA	ULT CA	TEGORY		···· <u>·</u>			
Landi	ng (Gear				General		_						
		Bending				Bend		Folio/F	Program	<u>L</u>	Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u>L</u>	Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં	Ш	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs .		Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Ш	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Unc	lear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
		Heat Trea	ət			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	•			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration		·			
		Wave/Tw				Fit/Function		Out of S	Sequence					

Work Order ID 121924 *121924* Monday, July 07, 2014 9:49:42 AM Item ID: D3453-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Clevis **Start Date:** 7/07/14 **Start Qty: 10.00** *10* **Cust Item ID:** Required Date: 7/07/14 Req'd Otv: 10.00 *10* **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: **Tooling:** Date: Stop QC: Date:___ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID Description Run Hours** Code **Qty** Qty Number Stamp 170 Identify as per dwg & Stock Location: 11/ACC 2 *170* OCT 0 7 2014 Packaging 0.00 Memo Packaging *****STOCK IN LARGE FAB*****

180

QC21- Final Inspection - Work Order Release

0.00

120

QC

Quality Control

Memo

0.00

Insp.

Page 2

DQA:	Date:								_				TOART		
				,		WORK ORDER NON	-CC	ONFO	RMANCE / UP				AEROSPACE		
QA Closed:			Date:								Vork Order u	date only			
Work Orde	ar.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orac						Rework			Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	lo.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	NCR No.			Suspected Unapproved]		Large Fab Composite		Supplier						
Root		,	1		Desc	ription of work order update		nitial	Actio	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector		
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator		71 F 3													
Offset/Setup									•						
Process															
Supplier	·														
Training			ļ												
Transport															
Unapproved					<u> </u>						1				
							FA	ULT CAT	regory						
Landi		1			_	General	_	1		г	70	: Г	Pressure/Forced		
	-	Bending			<u> </u>	Bend	\vdash	4	rogram	}-	Outside Dim	├	Set-up		
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	Ŀ	Grain		 -	Over/Under Part Incorre	—	Temperature/Cure		
		Cracks	-l./D:l-	Malaura	-	Broken/Damage/Defect	┝	Hardwa		auglified	Part Lost/M	ļ	Weld		
	Н	Crimp/Kir	тк/кірріе,	/ wave	-	Burrs	\vdash	1	ion Incomplete/Und ions Incomplete/Ui	-	Part Moved	1331118	Wrong Stock Pulled		
	<u> </u>	Cuffs				Contamination Countersink	 	4	ned/off center	-	Positioned \	L Vrong			
	\vdash	Crushing Heat Trea				Cut Too Short	\vdash	Mislabe		-	Power Loss/		Other		
	-	Inspection		Tuhe	-	Drawing		Misread		L	Vc. 2033/		15		
	_	Marks/Ch	-	iube		Drill Holes		Off-set					<u>, </u>		
	\vdash	Turning S	*			Finish		4	Calibration				- A /A V.		
		Wave/Tw			-	Fit/Function	H	4	Sequence						
1		1		-		1	_		•						

Picklist Print

Monday, July 07, 2014 9:49:42 AM

Work Order ID: 121924

D3453-3

121924

Parent Item Name: Clevis

D3453-3

Start Date: 7/07/14

Required Date: 7/07/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

Parent Item:

A05.09.27New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No			100	f	22,5133	0.2452	2.452			
M304R1 304 round bar 1.250	250								**	2.434		14/0/06	DAS 40 9-89

Location	Loc Oty	Loc Code	
MAT029	22.5133		
m126151	1.8		
→ m126647	12		3,1
m128496	8.7133		

Page 1

DQA:			. Date:						21441GE / UDDATE				DART
QA Closed:			Date:			WORK ORDER NOT	N-C(ONFOI	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
						DISPOSITION			AGAIN	IST DE	PARTMENT,	/PROCESS	
Work Orde Part N NCR N	- _ No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstu Machining Small F noforming Finish Large Fab Compos	ab ing	4 '	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1				Desc	I ription of work order update	<u>. T</u>	Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance		nief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FA	ULT CA	regory				
Landi		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspectio Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	-	Wave/Tw				Fit/Function		-	Sequence				

DART AEROSPACE LTD	Work Order:	121924
Description: Clevis	Part Number:	D3453-3
Inspection Dwg: D3453 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+/-0.030	1.129			VERN	A10-12
Ø0.755	+0.002/-0.005	.7547			Mic	P40-02
2.74	+/-0.030	2.740			YERN	P-0-1Z
1.220	+/-0.010	1, 219			MiC	P/-10-09
1.00	+/-0.030	1,000			VERN	940-12
0.500	+0.010/-0.000	501			1.	1~
Ø0.375	+0.006/-0.001	.377			14	λ
Ø0.129	+0.005/-0.001	. 130	/		1-	٠.
0.625	+/-0.010				L	f)
0.450	+/-0.010	.629 .448	· V	:	1	,,
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	^	,				

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	DAS					

Measured by: See Audited by: Preliminary Approval:

Date: 19/0/05 Date: 14/0-4 Date:

A 06.09	.01 New Issue	10000	
	. O 1 14CW 133UC	KJ/JLM	
B 09.11	04 Dimensions updated per Dwg Rev B	KJ 10	
C 13.04		KJ 📲	M

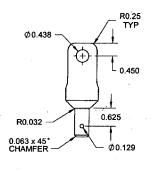


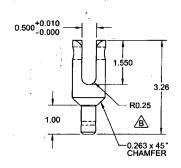
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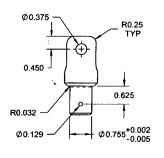
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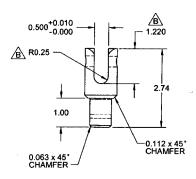


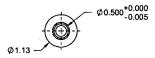
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D3453-1 CLEVIS

SHOP COPY

RETURN TO **ENGINEERING**

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER 121924 MLJ 14-07-07

D3453-3 CLEVIS

		···						
В	WAS 0.1	NG UPDATED 050 (ZN C5-1, R 09-018	TO CURRENT STANDARDS; R0.25 C2-1); 1.220 WAS 1.175 (ZN D1-1);	RF	09.05.21			
Α	NEW IS	SUE		RF	05.09.02			
REV.			DESCRIPTION	BY	DATE			
DESIG	N	RF	DART AEROSP	ACE L	TD			
DRAW	N	RF		HAWKESBURY, ONTARIO, CANADA				
CHECK	ŒĎ	W	DRAWING NO.		REV. B			
MFG. A	PPR.	11	D3453	SHEET 1 OF				
APPRO	VED		TITLE		SCALE			
DE API	PR.	2 47/	CLEVIS	NTS				

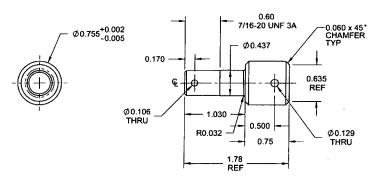
COPYRIGHT © 2005 BY DART AEROSPACE LTD

D3453-1/-3 NOTES:
1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE 7) WEIGHT: D3453-1 = 0.41 lbs D3453-3 = 0.41 lbs

DATE

09.05.21



D3453-5 PLUG

D3453-5 NOTES:

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.13 lbs

DESIGN RF		DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARK), CANADA				
CHECKED	Q 1	DRAWING NO.	REV. B				
MFG. APPR.	120	D3453	SHEET 2 OF 2				
APPROVED	XMY	TITLE	SCALE				
DE APPR.	d-	CLEVIS	NTS				
DATE 09.0	5.21	COPYRIGHT @ 2005 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND COMPERATION, AND IS IMPREDOR THE COMPRESS CONCIDENT THAT IT IS NOT TO BE USED FOR ANY AEROSES ON COMPETE ON COMMANDAL TO TO ANY OTHER PERSON WITHOUT WITH THE RepresSHOP FINE ON ANY AEROSPACE LTD.					

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